

Work Order ID 86480

86480

Page 1

Item ID: D4545-048

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Inner, RH (Top)

Start Date: 29/06/2012 Start Qty: ~~10.00~~ ¹²

10

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/06/29* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D4545 C

100 Pick Kit

0.00

100

Packaging Memo

0.00

Packaging

110

0.00

110

Small Fab Memo

0.00

Small Fab

1- ASSEMBLE AND BEND TABS AS PER DWG

2- DISASSEMBLE AND DEBURR

3- DIMPLE HOLES AS PER DWG

[Handwritten signatures and dates: 12/06/29, 12/07/29]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86480

June-29-12 1:31:06 PM

86480

Page 2

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Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 Smb 0.00 12-8-14	DAS 16	12 bsl4		12			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12		12-8-15	
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				12			12/08/15

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

145

0.00

145

Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AND ASSEMBLE AS PER DWG

12K

[Signature] 12/08/15

147

QC5- Inspect part completeness to step on W/O

0.00

147

QC

Memo

0.00

Quality Control

SMB
12-8-15

DAS
16
8-15
12/08/15

12
(-048)

190

Identify as per dwg & Stock Location: *163*

0.00

190

Packaging

Memo

0.00

Packaging

of Sh *12/08/16*

W/O:		WORK ORDER CHANGES					
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Work Order ID 86480***86480***

Page 4

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Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 12/08/16

MLJ 12/08/16

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NOTE: Date & initial all entries

Picklist Print

June-29-12 1:31:10 PM

Page 1 / 2

Work Order ID: 86480

86480

Parent Item: D4545-048

D4545-048

Parent Item Name: Retainer, Inner, RH (Top)

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM IPP REV:B
12.02.27 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.05.08
as per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-7		Manufactured	No			100	Each	8.0000	1	10			

D4541-7

Bracket

**

Location

Loc Qty

Loc Code B87973

FG

-1

B87973

78768

3

81264

2

GA

9

84961

3

D4542-7

Manufactured No

100

Each

9.0000

1

10

D4542-7

Retainer, Inner

**

Location

Loc Qty

Loc Code B87971

FG

3

78774

3

GA

6

81269

4

84962

2

MS20426AD3-4

Purchased No

145

Each

2,750.000

16

160

MS20426AD3-4

RIVET

**

Location

Loc Qty

Loc Code

ST316

2750

104374

236

110398

2514

192

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June-29-12 1:31:10 PM

Page 2

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Parent Item: D4545-048

Parent Item Name: Retainer, Inner, RH (Top)

86480

D4545-048

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 10.00

Required Qty: 10.00

MS21059L3K

Purchased

No

145

Each

206.0000

8

80

MS21059I 3K

**

Nutplate

Location

Loc Qty

Loc Code

ST302

206

121114

206

Handwritten signature and date: 9/5/12 / 08/15
Handwritten number: 96

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5F	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86480 MLJ
12/06/29

RELEASED
2012-05-07
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: AFTER FORMING AND PRIOR TO ASSEMBLY, CHEMICAL CONVERSION COAT D4541-X & D4542-X PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC..) VALUE

C	CHG FINISH (ZN A8-1); D4541-5F WAS -5 (C4-1) REMOVE TRANSFER DRILL NOTES	CP	12.04.20
B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. C SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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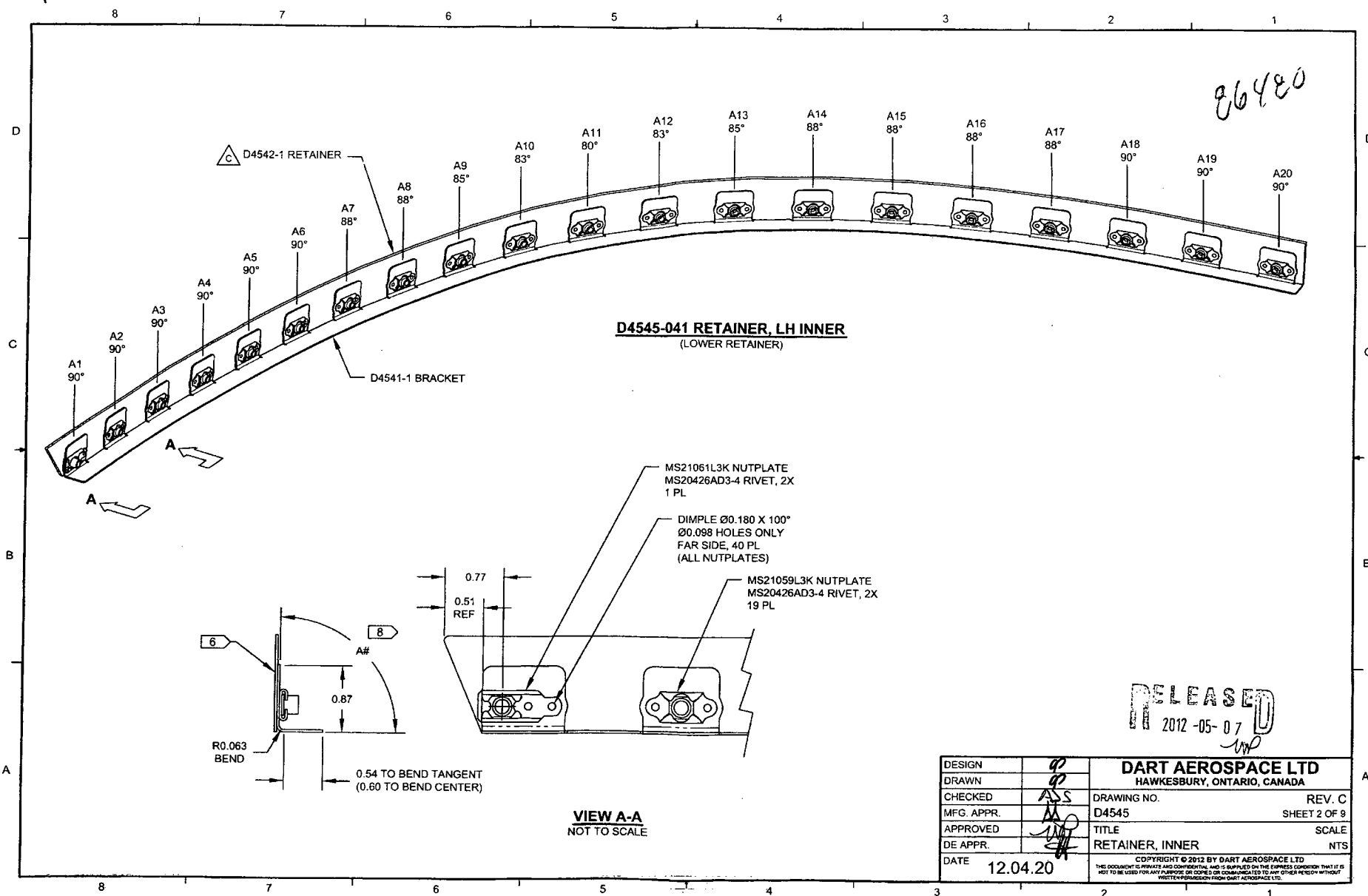
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

86480



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2012-05-07

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DRAWN	92		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 2 OF 9
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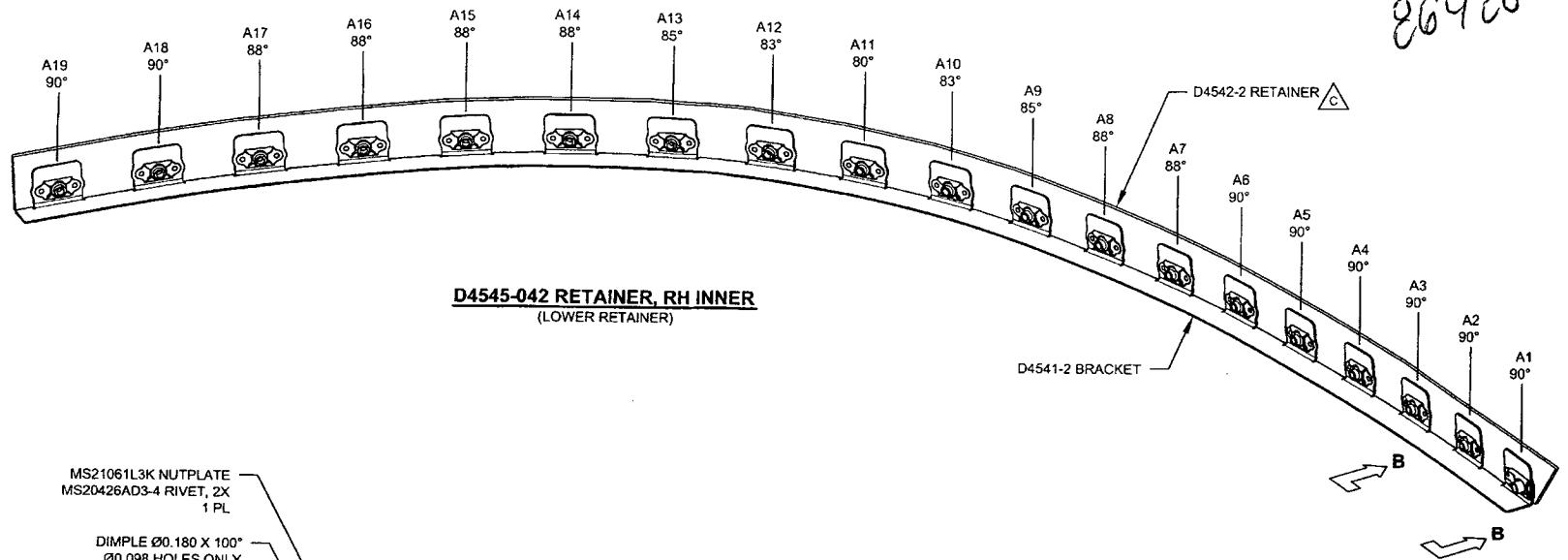
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26480

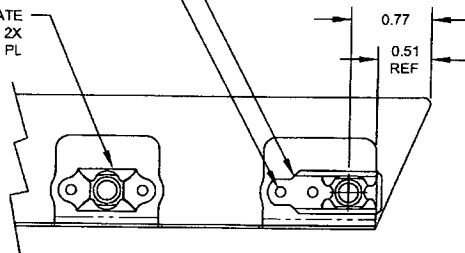


D4545-042 RETAINER, RH INNER
(LOWER RETAINER)

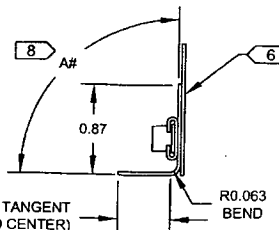
MS21061L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
1 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 38 PL
(ALL NUTPLATES)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
18 PL



VIEW B-B
NOT TO SCALE



2012-05-07

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MFG. APPR.		D4545	SHEET 3 OF 9
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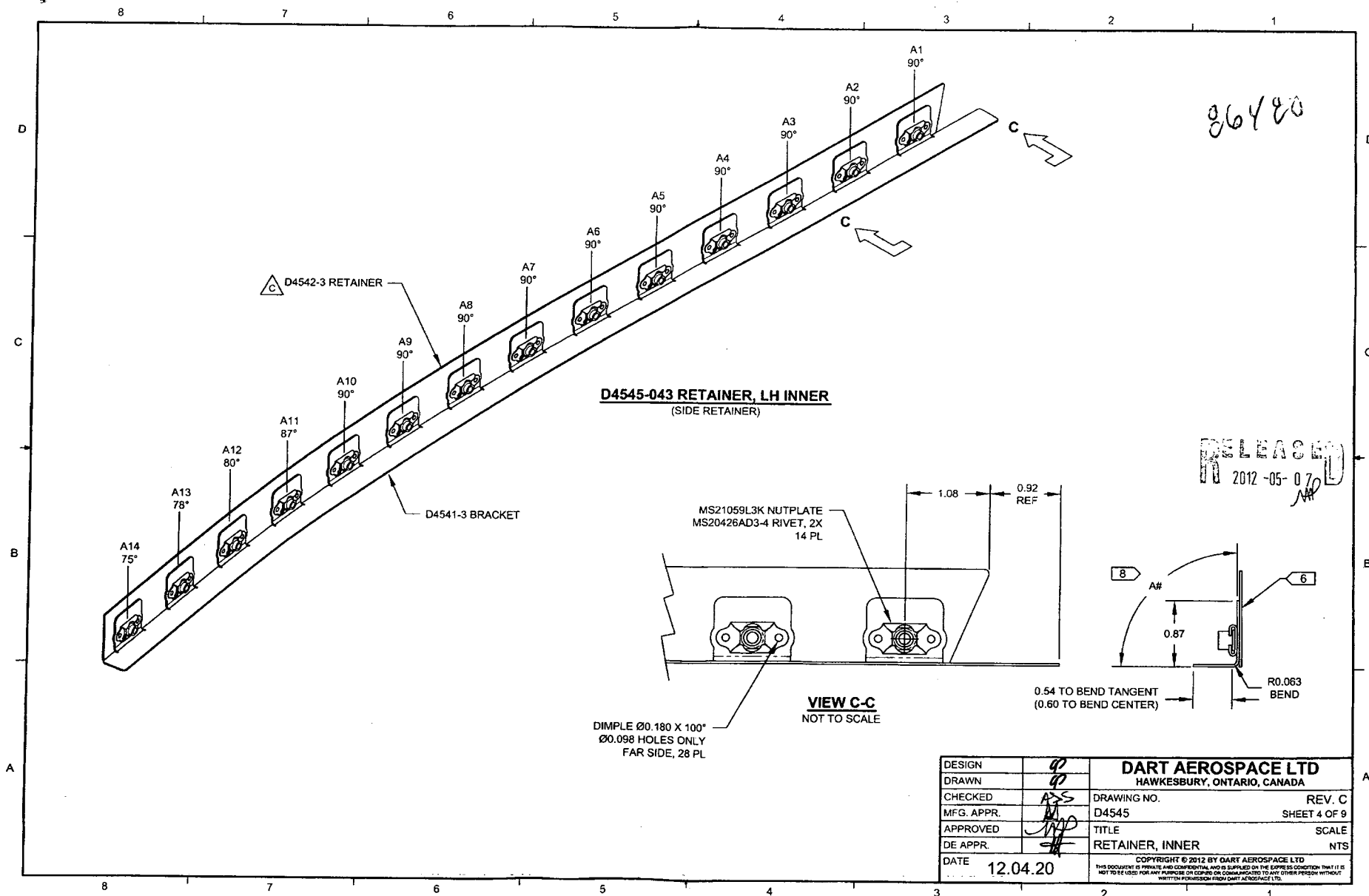
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86480

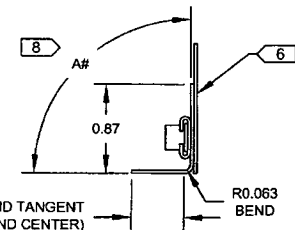
RELEASED
2012-05-07

D4545-043 RETAINER, LH INNER
(SIDE RETAINER)

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 PL

VIEW C-C
NOT TO SCALE

0.54 TO BEND TANGENT
(0.60 TO BEND CENTER)



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DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4545	SHEET 4 OF 9
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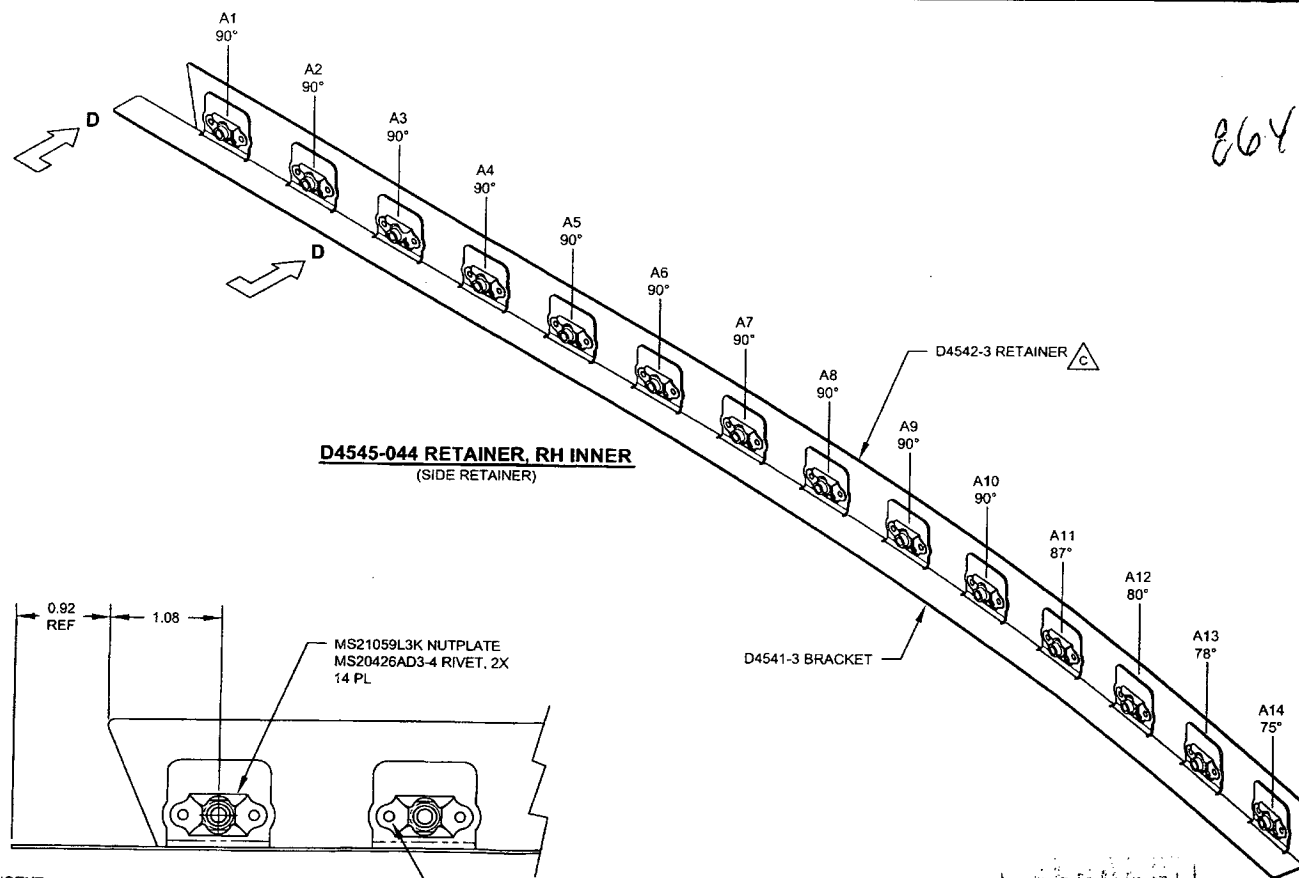
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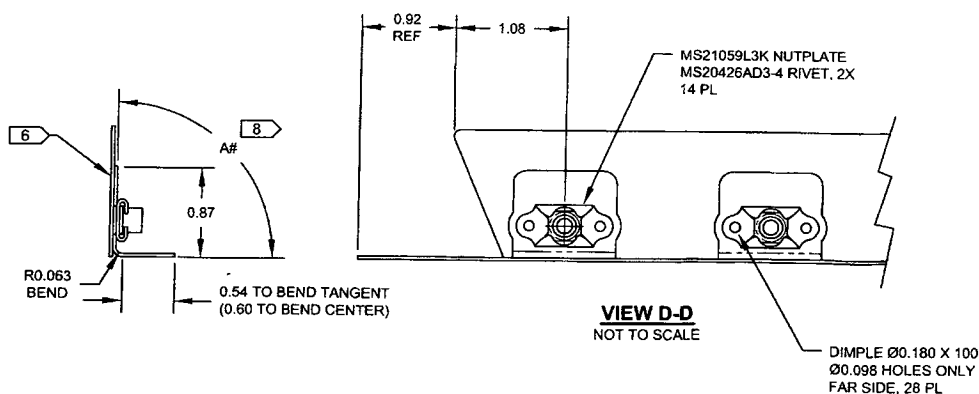
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D4545-044 RETAINER, RH INNER
(SIDE RETAINER)



2012-05-03

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
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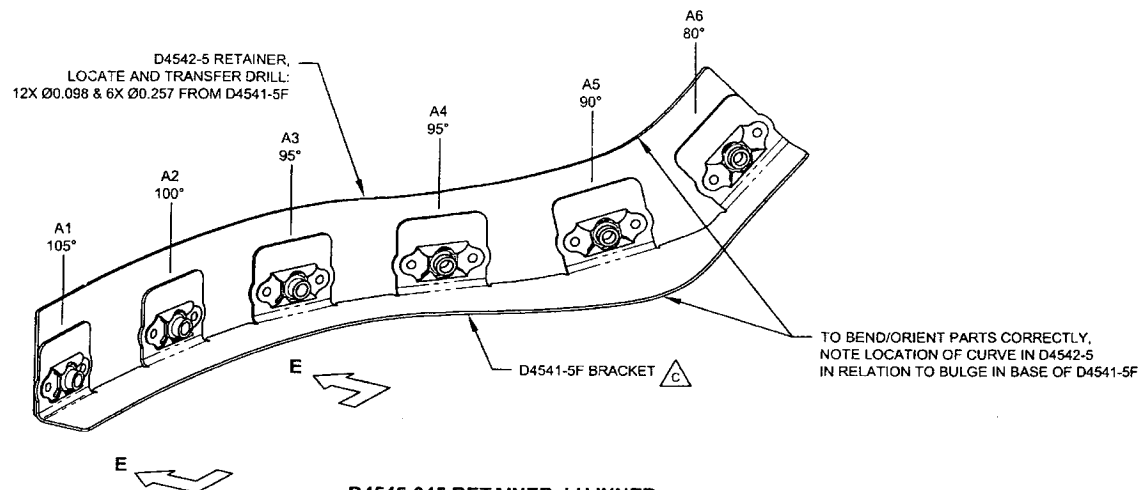
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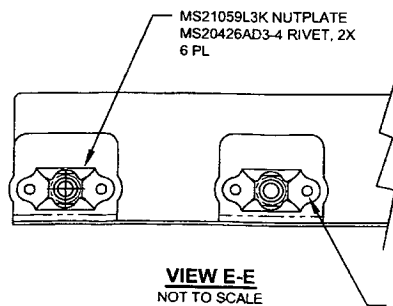
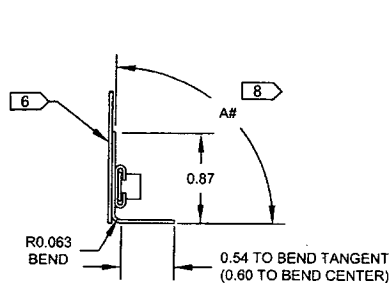
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26480



D4545-045 RETAINER, LH INNER
(TOP CORNER RETAINER)



DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 12 PL

DESIGN		DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D4545	REV. C
MFG. APPR.		SHEET 6 OF 9	
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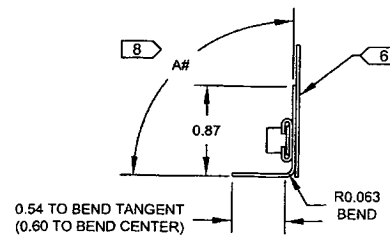
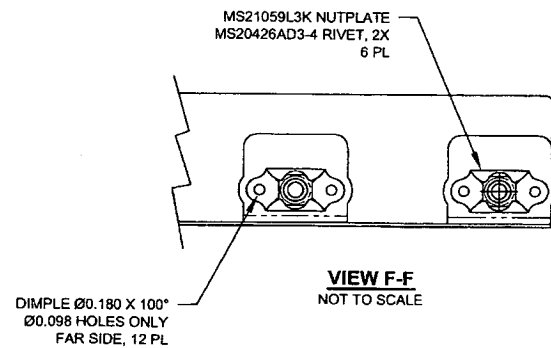
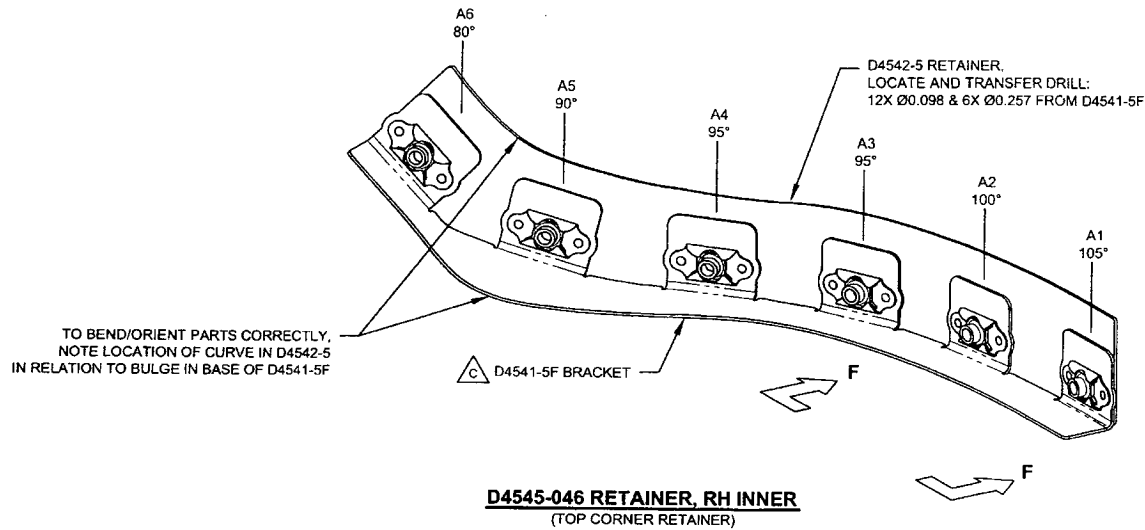
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RELEASED
2012-05-07

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MFG. APPR.		D4545	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

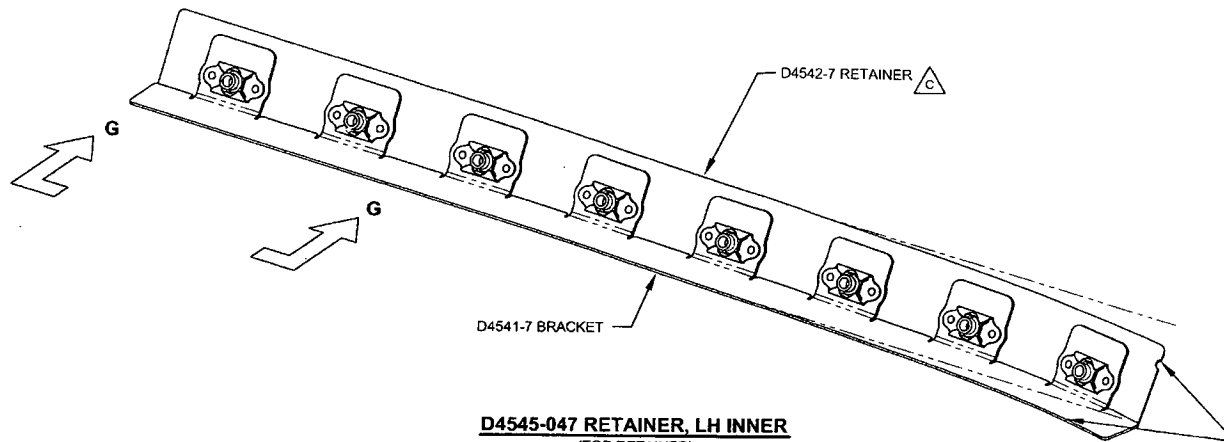
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

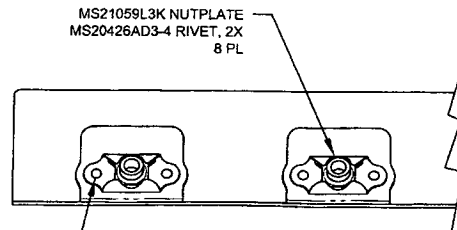
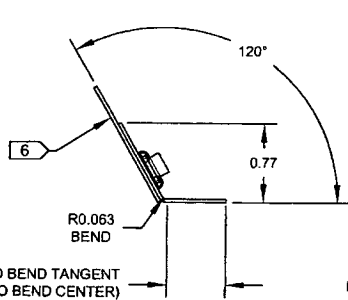
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4545-047 RETAINER, LH INNER
(TOP RETAINER)



DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW G-G
NOT TO SCALE

RELEASE
2012-05-03

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	ASS	DRAWING NO. D4545	REV. C
MFG. APPR.			SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ORIENT NOTCH AS SHOWN,
FOR THIS W/O ONLY

9/12/11 Q51042

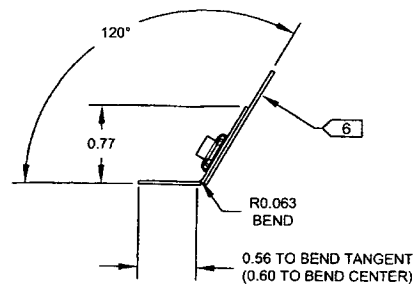
TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7

△ D4542-7 RETAINER

D4541-7 BRACKET

D4545-048 RETAINER, RH INNER
(TOP RETAINER)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL



DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW H-H
NOT TO SCALE

2012-05-07
MJP

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D4545	REV. C
MFG. APPR.	MJP	SHEET 9 OF 9	
APPROVED	MJP	TITLE SCALE	
DE APPR.	MJP	RETAINER, INNER NTS	
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries